

M-316LSi

For austenite stainless steel (Low carbon, 18%Cr-8%Ni STS))

Classifications

EN ISO 14343-B:2009	: G 19 12 3 L Si
EN ISO 14343-B:2009	: SS 316LSi
JIS Z 3321:2013	: YS316LSi
AWS A5.9-2012	: ER316LSi

Approvals – I1 (100% Ar)

Other	: TUV
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Welding positions



Polarity & shielding gas

- DCEP (DC+)
- Ar + 1-3% O₂ (15 – 25 l/min)
- Ar + 1-5% CO₂ (15 – 25 l/min)

Description

- MIG welding of 18%Cr-12%Ni-2%Mo austenite stainless steels (AISI STS 316, 316L)
- Various applications of chemical plant, fiber and paper industrial apparatuses

Typical chemical composition of all-weld metal (%)

C	Si	Mn	Ni	Cr	Mo
0.01	0.87	1.55	11.57	18.58	2.54

Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation	Impact Value (J)	
	(MPa)	(MPa)	(%)	0 °C	-196 °C
AWS A5.9		Min. 490	Min. 30		
EN ISO 14343	Min. 320	Min. 510	Min. 25		
Example	432	613	37	127	57